

Work Order ID 162663

162663

Page 1

Wednesday, June 07, 2017 10:55:16 AM

Item ID: D350-615-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: GHW Modification, Fits LH or RH
 Start Date: 6/7/2017 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/19/2017 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: ^{DAS}21 Date: JUN 07 2017 Tooling: Date: Run Start *NR1*
 QC: ⁹⁻⁸⁹ Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D350-615	B ✓	JUN 07 2017	DAS 6 9-89						

100	Document Control	0.00							
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100
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003
 20x ^{DAS}27 ⁹⁻⁸⁹
 JUN 15 2017

110		0.00							
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110
 Small Fab Memo 0.55
 Small Fab Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C bolts***
 20 ∅ JUN 14 2017 ^{DAS}19 ⁹⁻⁸⁹

120	QC5: Inspect part completeness to step on W/O	0.00							
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120
 QC Memo 0.40
 Quality Control
 20 ^{DAS}38 ⁹⁻⁸⁹
 JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
								OTHER :	

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 Required Date: 6/19/2017 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.60				20	DAS 28 9-89	JUN 15 2017	
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023	0.00 0.00				20	DAS 27 9-89	DAS 28 9-89	JUN 15 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 2.00						17/6/19	DAS 21 9-89

JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 162663

162663

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 6/7/2017

Required Date: 6/19/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041		Manufactured	No			110	Each	62.0000	1	20			DAS
D2282-041									**			JUN 14 2017	19 9-89
T Assembly													

Location Loc Qty Loc Code

GA

62

161266

2

161339

60

D2282-043

Manufactured No

110

Each

0.0000

1

20

D2282-043

Saddle Assembly

**

JUN 14 2017

DAS
19
9-89

5/16-18-015C

Purchased No

110

Each

24.0000

3

60

5/16-18-015C

SS Bolt 5/16-181.5"

**

13TT70x36

DAS
6
9-89

JUN 07 2017

Location

Loc Qty

Loc Code

ST583

24

m137100

24

D3015-3

Manufactured No

110

Each

122.0000

3

60

D3015-3

Locknut

**

x36

JUN 07 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

104

158471

4

161702

100

4

56

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 162663

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Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 6/7/2017

Required Date: 6/19/2017

Start Qty: 20.00

Required Qty: 20.00

5/16WC Purchased No 110 Each 75.0000 12 240

5/16WC

Washer

**

JUN 07 2017

DAS

18x 13770

6

9-89

Location

Loc Qty

Loc Code

ST583

53

m137324

53

WA001

22

m136525

22

7/16-14-050C

Purchased No

110 Each

70.0000

1

20 JUN 07 2017

**

DAS

6

9-89

7/16-14-050C

SS Bolt 7/16 5" Long

Location

Loc Qty

Loc Code

ST584

70

m137719

70

D3015-5

Manufactured No

110 Each

30.0000

1

20

**

JUN 07 2017

DAS

6

9-89

D3015-5

SS Nylock Nut 7/16

Location

Loc Qty

Loc Code

ST015

30

160671

30

7/16WC

Purchased No

110 Each

375.0000

2

40

**

JUN 07 2017

DAS

6

9-89

7/16WC

Washer, SS Flat 7/16

Location

Loc Qty

Loc Code

ST5584

58

M137547

58

ST584

317

M137581

317

Wednesday, June 07, 2017 10:55:22 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162663

162663

Wednesday, June 07, 2017 10:55:16 AM

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Item ID: D350-615-041

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Start Date: 6/7/2017 Start Qty: 20.00

Required Date: 6/19/2017 Req'd Qty: 20.00

20
20

Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date: JUN 07 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-615	B	JUN 07 2017							

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003

0.00

110

110

Small Fab

Small Fab

0.55

Memo

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

0.00

QC5- Inspect part completeness to step on W/O

120

120

QC

Quality Control

Memo

0.40

CB

20

JUN 12 2017